

Work Order ID 108106

108106

Page 1

October-07-13 9:11:38 AM

Item ID: D350-689-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Provisions

Start Date: 10/07/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/07/13 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: MLJ

Date: 13-10-07

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI9588

B

IIN D350-689

B

0.00

DAS
27
9-89

100

100

DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy D350-689 bluefile & type labels per PPP D350-689-013 CHG 005

101

Pick Kit

0.00

101

Packaging

Memo

0.00

Packaging

DAS
33
9-89

13-10-23

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 108106

October-07-13 9:11:38 AM

108106

Page 2

Item ID: D350-689-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Provisions

Start Date: 10/07/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/07/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110 QC4- 100% Inspect kits for completeness 0.00

110

QC Memo Quality Control

0.00
DAS
27
9-89
B 1031

120 Packaging 0.00

120

Packaging Memo Packaging Identify and pack for shipping as per PPP D350-689-013
Location: 041
PPP Rev: G

1 13/10/13 DAS 6 9-89

130 QC21- Final Inspection - Work Order Release 0.00

130

QC Memo Quality Control

MCG 1371-01
ME
13-11-01

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

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Page 1

Work Order ID: 108106
Parent Item: D350-689-013
Parent Item Name: Floor Provisions

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev D 06.02.07 Re-format ec
IPP rev E 06.02.28 Fixed typo ec
IPP rev F 07.01.02 per dsi 9311 ec
D3033-1 DD verf:EC IPP REV;H 11.11.17 PER IIN REV B DD VERF;EC IPP
REV:I 11.11.24 AS PER ECN11-674 DD VERF:EC IPP REV:J 12.11.20 AS PER DSI9588
REV:B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4575-3 Doubler		Manufactured	No			110	Each	3.0000	1	1			DAS 32 9-89
DAS 27 9-89				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST256		3							
				100805		3							
D3025-1 Beam		Manufactured	No			110	Each	5.0000	1	1			DAS 33 9-89
DAS 27 9-89				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST177		5							
				95370		5							
D4575-0 Beam		Manufactured	No			110	Each	7.0000	1	1			DAS 33 9-89
DAS 27 9-89				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST177		7							
				101084		3							
				103070		2							
				95943		1							
				97998		1							
D3027-1 Clip		Manufactured	No			110	Each	12.0000	1	1			DAS 33 9-89
DAS 27 9-89				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST024		12							
				96360		12							

4

107967

95370

103070

13-10-23

96360

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
---	---	---

<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 2

Work Order ID: 108106
Parent Item: D350-689-013
Parent Item Name: Floor Provisions

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 1.00

Required Qty: 1.00

D3027-3 Clip	Manufactured No	110 Each	12.0000	1	DAS 33 9-89
DAS 27 9-89	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	103088	
	ST024	12			
	103088	9			
	86972	3			
D3027-5 Clip	Manufactured No	110 Each	12.0000	1	DAS 33 9-89
DAS 27 9-89	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	102841	
	ST024	12			
	102841	10			
	93058	2			
D3027-7 Clip	Manufactured No	110 Each	12.0000	1	DAS 33 9-89
DAS 27 9-89	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	106800	
	ST024	12			
	102929	12			
D3032-1 Spacer	Manufactured No	110 Each	12.0000	1	DAS 33 9-89
DAS 27 9-89	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	96165	
	ST177	12			
	96165	12			
D3033-0 Seat Track	Manufactured No	110 Each	8.0000	2	DAS 33 9-89
DAS 27 9-89	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	102967	13-10-23
	ST177	8			
	102967	6			
	106834	1			
	95866	1			

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Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY									
Landing Gear			General						
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong						
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other					
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							

Picklist Print

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Page 3

Work Order ID: 108106

Parent Item: D350-689-013

Parent Item Name: Floor Provisions

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 1.00

Required Qty: 1.00

D323451 Doubler	Manufactured	No	110	Each	5.0000	DAS 6 9-89	1	DAS 33 9-89
<div> <div>DAS 27 9-89</div> <div> <u>Location</u> ST177 88274 </div> <div> <u>Loc Qty</u> 5 5 </div> <div> <u>Loc Code</u> </div> </div>								
D323455 Spacer	Manufactured	No	110	Each	4.0000	DAS 6 9-89	13 10.29 ² 7	DAS 33 9-89
<div> <div>DAS 27 9-89</div> <div> <u>Location</u> ST034 92835 </div> <div> <u>Loc Qty</u> 4 4 </div> <div> <u>Loc Code</u> </div> </div>								
MS21059L3 Nut Plate	Purchased	No	110	Each	163.0000	DAS 6 9-89	12 12	DA 33 9-89
<div> <div>DAS 27 9-89</div> <div> <u>Location</u> ST316 124291 125535 m126275 ST506 124308 </div> <div> <u>Loc Qty</u> 152 7 51 94 11 11 </div> <div> <u>Loc Code</u> </div> </div>								
MS24693-S273 Screw	Purchased	No	110	Each	584.0000	DAS 6 9-89	2 2	DAS 33 9-89
<div> <div>DAS 27 9-89</div> <div> <u>Location</u> ST301 100151 117291 </div> <div> <u>Loc Qty</u> 584 484 100 </div> <div> <u>Loc Code</u> </div> </div>								

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Shop Packet Print

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

October-07-13 9:11:38 AM

Page 4

Work Order ID: 108106
 Parent Item: D350-689-013
 Parent Item Name: Floor Provisions

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 1.00

Required Qty: 1.00

MS27039-0-10
 SCREW

Purchased No

110 Each

710.0000

6

6

DAS
 33
 9-89

Location

Loc Qty

Loc Code

GA	100	
120449	100	
ST305	182	
122815	1	
124859	100	
125654	81	
ST308	18	
123522	18	
ST506	410	
124326	10	
m126474	400	

DAS
 27
 9-89

NAS1149D0332J
 Washer

Purchased No

110 Each

1,417.0000

6

6

DAS
 33
 9-89

12-10-23

Location

Loc Qty

Loc Code

ST293	37	
125268	37	
ST294	1380	
122973	81	
125044	99	
m125807	1200	

DAS
 27
 9-89

126474
 125807

October-07-13 9:11:38 AM

Shop Packet Print

Page 4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. B AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV. 1

REF. TCCA STC: SH02-33
REF. FAA STC: SR01620NY
REF. EASA STC: EASA.IM.R.S.01453
REF. TCA STC: 2005S03-09

1.0 PURPOSE

For D350-689-011/-013 at CHG 006/005 and later and D350-689-021/-023 Kits at CHG 005/004 and later, the D3026-1 Channel has been replaced with the D4575-1 Beam and D4575-3 Doubler and the D3234-3 Doubler has been removed. Consequently, the installation instructions for D350-689-011/-013 at CHG 006/005 and D350-689-021/-023 at CHG 005/004 are updated per Section 2.0 of this Service Instruction. The parts list update is shown in Section 4.0 of this Service Instruction. There is a negligible change to the weight and balance.

2.0 INSTALLATION CHANGES FOR D350-689-013

Section 3.9, *INSTALLATION OF D350-689-013 FLOOR PROVISIONS KIT* (pages 4 and 5 of IIN-D350-689), is changed as follows:

Item 3.3.15 is:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer as shown in Figure 1 of this Service Instruction. Transfer drill existing holes from the aircraft floor to the D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer as shown in Figure 1 of this Service Instruction and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Note: Drill a Ø1.00" (Ø25.4 mm) hole in the D4575-1 Beam to clear extension tube of collective and cutout as required for clearance of collective opening and fwd bulkhead as shown in Figure 3 of this Service Instruction.

Item 3.3.15 was:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D3026-1 Channel as shown in Figure 4 and transfer existing holes from the aircraft floor to the D3026-1 Channel & D3032-1 Spacer. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D3026-1 Channel & D3032-1 Spacer as shown in Figure 4 and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Item 3.3.17 is:

Counter sink holes in the D3032-1 Spacer for MS20426AD4 rivets. Install D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer to floor using MS20426AD4 rivets.

Item 3.3.17 was:

Counter sink holes in the D3032-1 Spacer for MS20426AD4 rivets. Install D3026-1 Channel and D3032-1 Spacer using MS20426AD4 rivets.

Item 3.3.22 is:

Rivet D3234-1 Doubler to D3025-1 Beam as shown in Figure 7 using MS20470AD4 rivets. Continue at step 3.3.25.

Item 3.3.22 was:

Rivet D3234-1 Doubler to D3025-1 Beam and D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets. Continue at step 3.2.25.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: D. Shepherd
D. SHEPHERD (DE # 02)
DATE: 12.11.09
CERT. NO.: SH02-33
ISSUE NO.: 1

B	CHANGES TO -013 KIT INSTALLATION. REF: CIR12-12.	MB	12.11.09
A	NEW ISSUE	MB	11.12.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
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MFG. APPR.	N/A	DSI 9588	SHEET 1 OF 6
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DE APPR.		INSTALLATION CHANGE	NTS
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13-10-07

3.0 INSTALLATION CHANGES FOR D350-689-023

Section 3.9, *INSTALLATION OF D350-689-023 ENERGY ATTENUATING FLOOR PROVISIONS KIT* (pages 8 and 9 of IIN-D350-689), is changed as follows:

Item 3.9.8 is:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D4575-1 Beam and D4575-3 Doubler as shown in Figure 2 of this Service Instruction. Transfer drill existing holes from the aircraft floor to the D4575-1 Beam and D4575-3 Doubler. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D4575-1 Beam and D4575-3 Doubler as shown in Figure 1 of this Service Instruction and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Note: Drill a Ø1.00" (Ø25.4 mm) hole in the D4575-1 Beam to clear extension tube of collective and cutout as required for clearance of collective opening and fwd bulkhead as shown in Figure 3 of this Service Instruction.

Item 3.9.8 was:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D3026-1 Channel as shown in Figure 4 and transfer existing holes from the aircraft floor to the D3026-1 Channel. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D3026-1 Channel as shown in Figure 4 and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Item 3.9.10 is:

Attach D4575-1 Beam and D4575-3 Doubler to floor using qty (14) MS20426AD4 rivets.

Item 3.9.10 was:

Attach D4575-1 Channel to floor using qty (14) MS20426AD4 rivets.

Item 3.9.12 is no longer applicable:

~~Rivet D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets.~~

Item 3.9.12 was:

Rivet D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets.

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BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

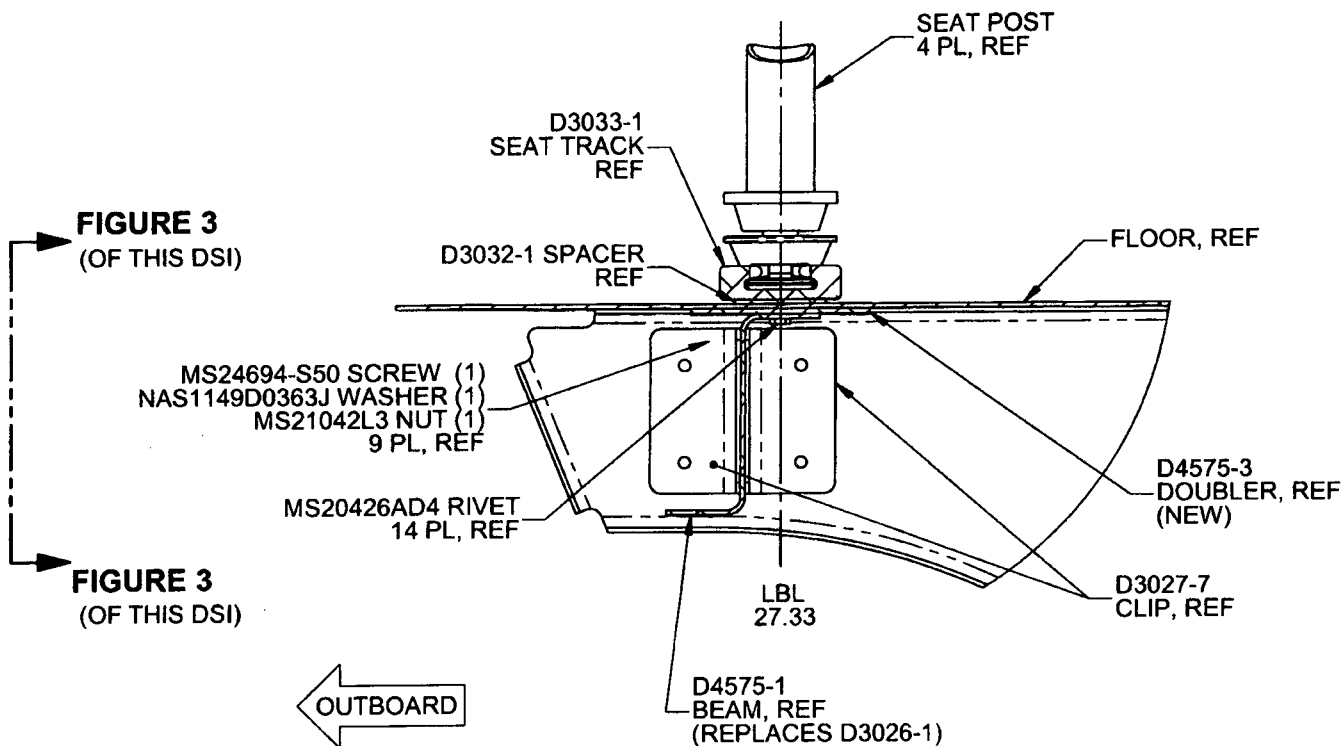
DATE: 12.11.09

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CROSS SECTION VIEW F-F/M-M: From Figures 5 and 7 (IIN-D350-689)
CROSS SECTION VIEW F-F/M-M: From Figures 25-5 and 25-7 (ICA-D350-689)






FIGURE 1: UPDATES TO CROSS SECTIONS F-F AND M-M
 With reference to Figures 5 and 7 of IIN-D350-689
 (Figures 25-5 and 25-7 of ICA-D350-689)

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 DAO # 01-O-01

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BY: *[Signature]*
 D. SHEPHERD (DE # 02)

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108106

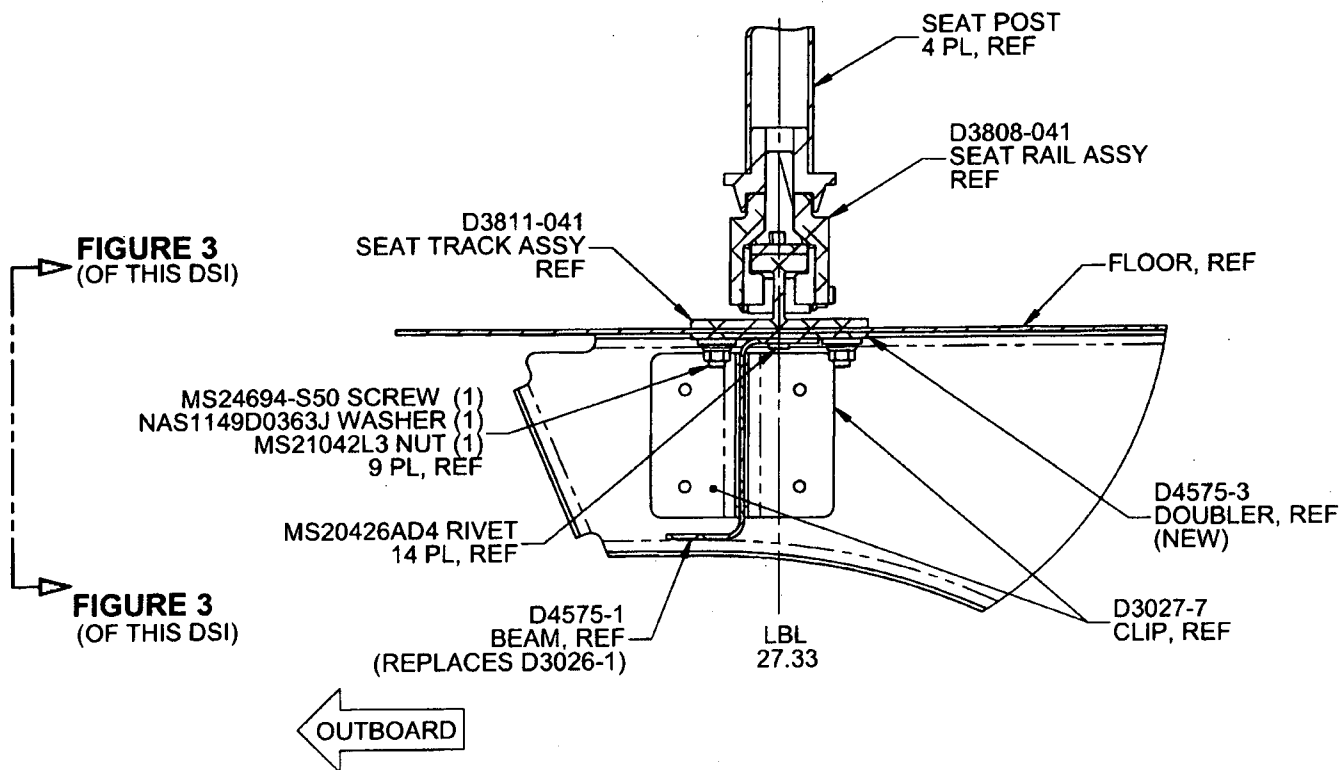


FIGURE 21: Cross Section View T-T from Figure 19 (IIN-D350-689)
FIGURE 25-21: Cross Section View T-T from Figure 25-19 (ICA-D350-689)

FIGURE 2: UPDATES TO FIGURE 21 (IIN-D350-689) AND 25-21 (ICA-D350-689)






With reference to Figures 19 and 20 of IIN-D350-689
 (Figures 25-19 and 25-20 of ICA-D350-689)

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 DAO #01-O-01

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 D. SHEPHERD (DE # 02)

DATE: 12.11.09
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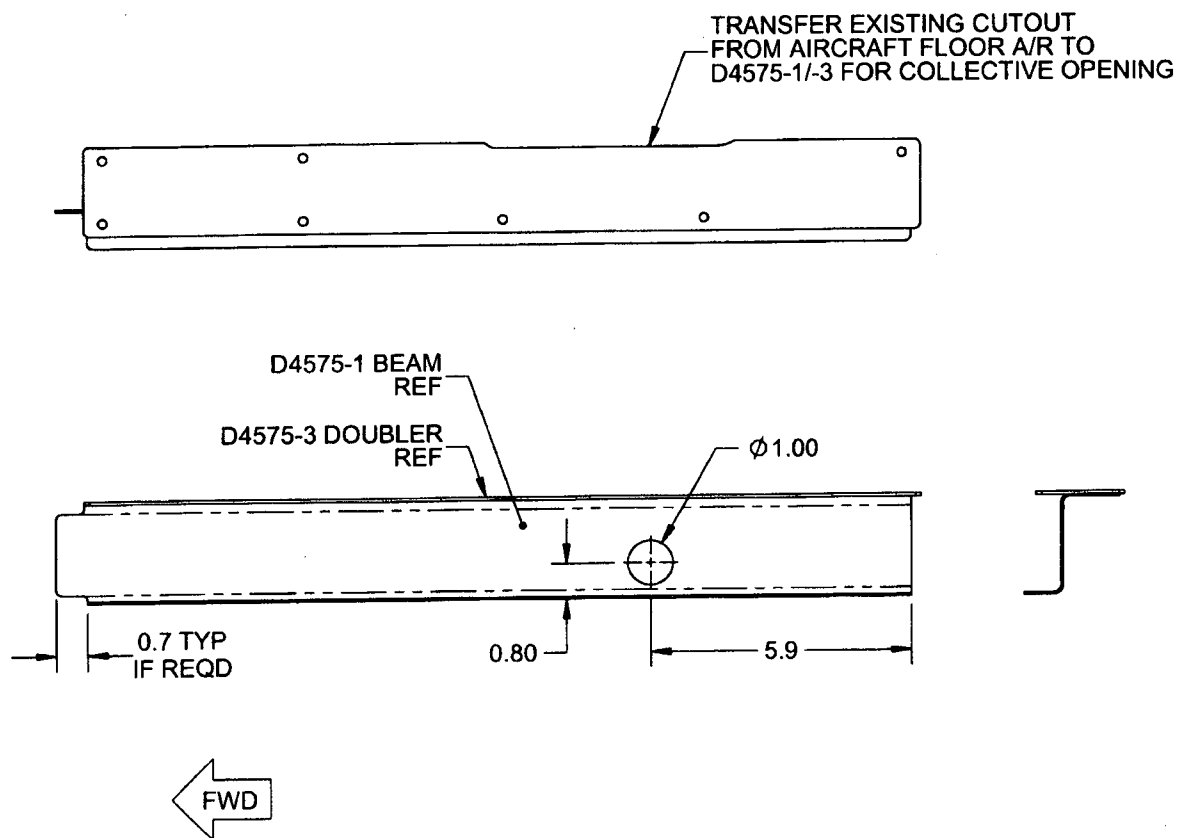


FIGURE 3: RELIEFS ON D4575-1/-3
(ONLY D4575-1/-3 SHOWN FOR CLARITY)
VIEW LOOKING INBOARD

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DAO # 01-O-01

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BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 12.11.09
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4.0 PARTS LIST CHANGE

The parts list of D350-689-021/-023 at CHG 005/004 or later is amended as follows:

5. PARTS LIST (IIN-D350-689) 25.10 PARTS LIST (ICA-D350-689)

IS:

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
		X							D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
					1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
									D3026-1	CHANNEL (REMOVED)
									D3234-3	DOUBLER (REMOVED)
	1					1			D4575-1	BEAM (REPLACES D3026-1)
	1					1			D4575-3	DOUBLER (NEW)

WAS:

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
		X							D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
					1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
	1					1			D3026-1	CHANNEL
	1					1			D3234-3	DOUBLER

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DEPARTMENT OF TRANSPORT
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BRANCH
DAO #01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE #02)

DATE: 12.11.09
CERT. NO.: SH02-33
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108/106

Item ID: D350-689-013

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Provisions

Start Date: 10/07/13 Start Qty: 1.00

1

Required Date: 10/07/13 Req'd Qty: 1.00

1

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 13-10-07 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

DSI9588

B

IIN D350-689

B

100

JB

0.00

MLJ 13-10-23

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D350-689 bluefile & type labels per PPP D350-689-013 CHG 005

101

Pick Kit

0.00

101

Packaging

Memo

0.00

Packaging

